

Date: Monday, 08/06/2009 2:20:46 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET RIB
Job Number :	48425		
Estimate Number :	10402		
P.O. Number :		Part Number :	D31661
This Issue :	08/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3166 REV.A2
First Issue :	//	Project Number :	N/A
Previous Run :	48215	Drawing Revision :	A2
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	12/06/2009
Written By :		Qty:	12
Checked & Approved By :	<u>Julie Dawson</u>	Um:	Each
Comment :	Est. A 02.08.23 New issue KJ Est. B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC Est Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W



Comment: Qty.: 5.2500 f(s)/Unit Total : 63.0000 f(s)
 304 SQ Tube.75x.75x.065W
 (M304TS0750W065)
 Material: 304/316 SS tube 0.065" wall

Batch M111835 SAD 09-06-09 (12)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 Cut 3/4" x 3/4" square tubing 60.00" long.

SAD 09-06-09 (12)

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

-Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

M 9-6-9 (12)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
 Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

SAD 09-06-10 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: WA

SAD 09-06-10 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 2:20:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 48425

Part Number: D31661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

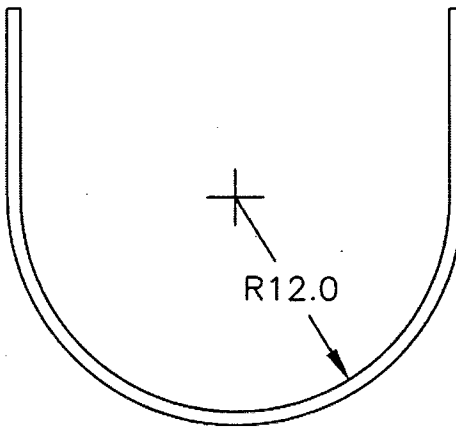
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

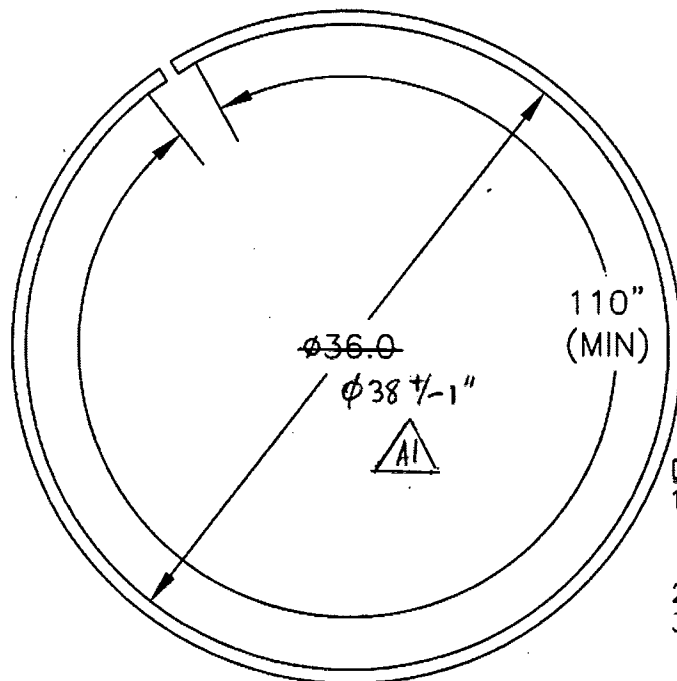
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38 +/- 1 WAS 36.0	

RELEASED
02.08.06

10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



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WORK ORDER
NO. 48425

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3166	TITLE BASKET HOOP	REV A1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08.12.16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)

REASON: SEE PAR 08-005

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